

Work Order ID 75206  
October-18-11 4:11:08 PM

Need to ship Oct 24 \*75206\* **Ship Today**

Page 1

Item ID: D3199-3

Revision ID:

Item Name: Bracket, Fwd LH

Start Date: 18/10/2011 Start Qty: 90.00

Required Date: 04/11/2011 Req'd Qty: 90.00

Reference:

Approvals: Process Plan: H.L.S

QC:

Accept

\*90\*

\*90\*

\*N900040100\*

Setup Start

\*NS1\*

Stop \*NS2\*

Cust Item ID:

Customer:

Date: 11/10/11

Tooling:

Date:

Run Start

Date:

SPC (Y/N):

Date:

Stop

\*NR1\*

\*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
----------	--------------

D3199	E
-------	---

100	FLOW WATER JET
-----	----------------

*100*	Memo
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Waterjet	Cut as per Dwg D3199
----------	----------------------

FLOW CNC Waterjet	Dwg Rev: <u>E</u>
-------------------	-------------------

	Prog Rev: <u>E</u>
--	--------------------

	Deburr if required
--	--------------------

110	QC2- Inspect parts off machine FAI/FAIB
-----	---

*110*	Memo
-------	------

QC	0.00
----	------

Quality Control	0.00
-----------------	------

BB-10-10

14

AB

BB-10-19

**Work Order ID 75206**

October-18-11 4:11:08 PM

Item ID: D3199-3

Revision ID:

Item Name: Bracket, Fwd LH

Start Date: 18/10/2011 Start Qty: 90.00

Required Date: 04/11/2011 Req'd Qty: 90.00

Reference:

Approvals: Process Plan:

Date:

QC:

Date:

Sequence ID/  
Work Center ID

120

**\*120\***

QC

Quality Control

Operation  
Description

QC8- Inspect parts - second check

Memo

130

**\*130\***

Brake NC

Brake NC

Bend as per dwg

Small Fab

Memo

140

**\*140\***

QC

Quality Control

QC5- Inspect part completeness to step on W/O

Accept

**\*90\*****\*90\***

Accept

**\*N900040100\***

Setup Start

Stop

**\*NS1\*****\*NS2\***

Cust Item ID:

Customer:

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	*NR1*			
Sequence ID/ Work Center ID	Operation Description	Date:	SPC (Y/N):	Date:	Stop	Stop	*NR2*			
120	QC8- Inspect parts - second check		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty Comments	Reject Qty	Reject Number	Insp. Stamp
<b>*120*</b>	QC		0.00	Su10/25			414	0		
QC	Quality Control		0.00					0	109	
130	Bend as per dwg	0.00								
<b>*130*</b>	Small Fab	0.00								
Brake NC										
Brake NC										
140	QC5- Inspect part completeness to step on W/O	0.00								
<b>*140*</b>	Memo	0.00								
QC										
Quality Control										

**\*75206\***

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Work Order ID 75206

\*75206\*

Page 3

October-18-11 4:11:08 PM

Item ID: D3199-3

Accept

\*N900040100\*

Setup Start

\*NS1\*

Revision ID:

Stop

\*NS2\*

Item Name: Bracket, Fwd LH

Start Date: 18/10/2011 Start Qty: 90.00

\*90\*

Cust Item ID:

Required Date: 04/11/2011 Req'd Qty: 90.00

\*90\*

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

\*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop

\*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

150

\*150\*

Powdercoat

Powder Coating

M 118489

Memo

8-00 0.00  
3200F  
8-30

2X / M-F 11/10/27

160

\*160\*

QC

Quality Control

QC3- Inspect Part Finish

0.00

2  
COUNTED

6 11/10/27

170

\*170\*

Packaging

Packaging

Identify as per dwg & Stock Location: \_\_\_\_\_

0.00

Memo

0.00

11/10/27 SF/20

Work Order ID 75206

\*75206\*

Page 4

October-18-11 4:11:08 PM

Item ID: D3199-3

Accept

\*N900040100\*

Setup Start

\*NS1\*

Revision ID:

Stop

\*NS2\*

Item Name: Bracket, Fwd LH

Start Date: 18/10/2011 Start Qty: 90.00

\*90\*

Cust Item ID:

Required Date: 04/11/2011 Req'd Qty: 90.00

\*90\*

Customer:

Reference:

Run Start

\*NR1\*

Approvals: Process Plan:

Date:

Tooling:

Date:

Stop

\*NR2\*

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

180

QC21- Final Inspection - Work Order Release

0.00

\*180\*

QC

Quality Control

Memo

0.00

W10/27 10/27

ME 10/27

**Picklist Print**

October-18-11 4:11:12 PM

Page 1

Work Order ID: 75206

**\*75206\***

Parent Item: D3199-3

**\*D3199-3\***

Parent Item Name: Bracket, Fwd LH

Start Date: 18/10/2011

Required Date: 04/11/2011

Start Qty: 90.00

Required Qty: 90.00

**Comments:** IPP RevA: RevC-prelim DD verified by:EC  
11.03.31 as per ecn 11-531 DD verf:EC

IPP Rev:B

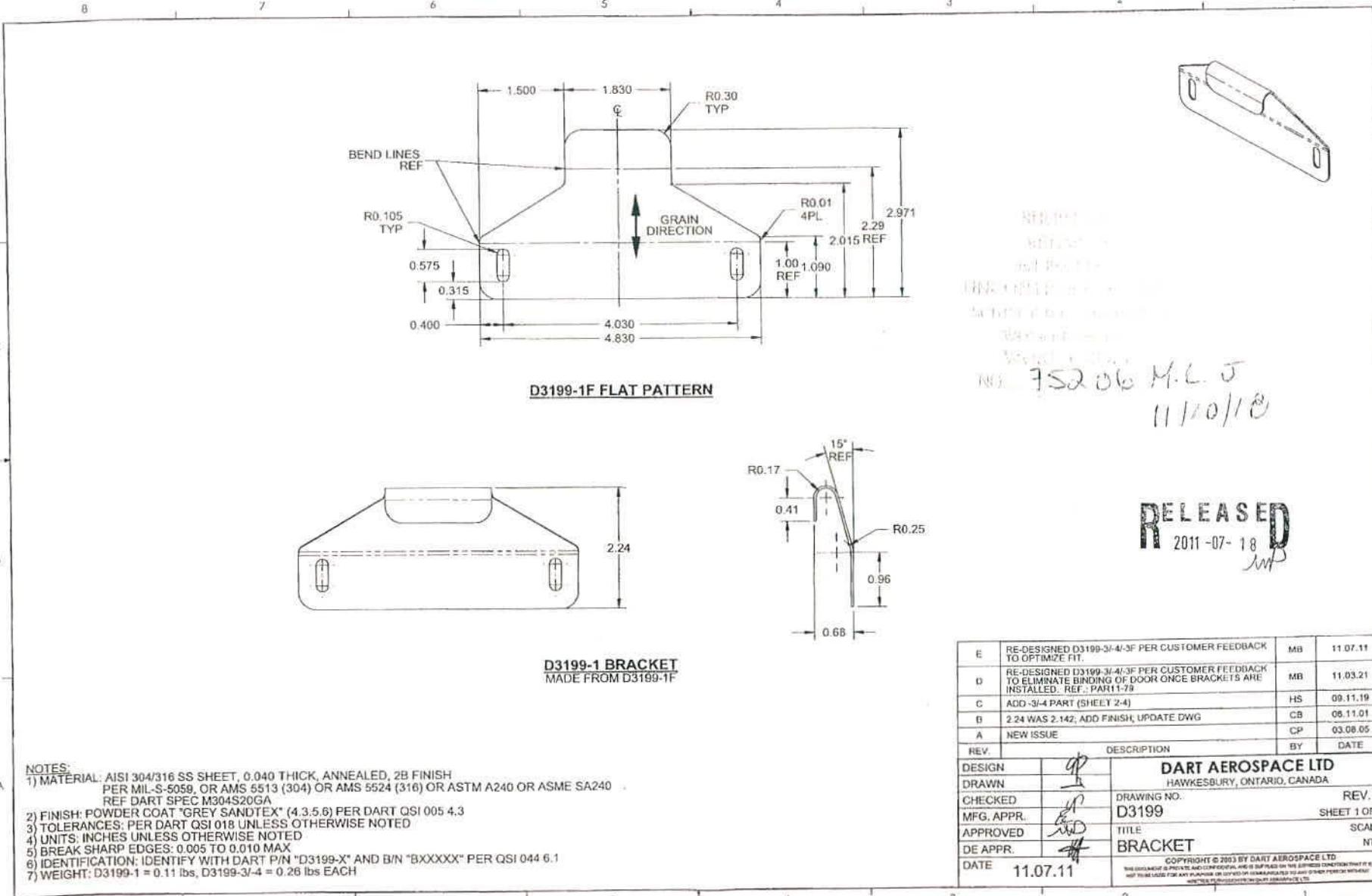
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA		Purchased	No			100	sf	137.0795	0.1673	15.84947			**

**\*M304S20GA\***

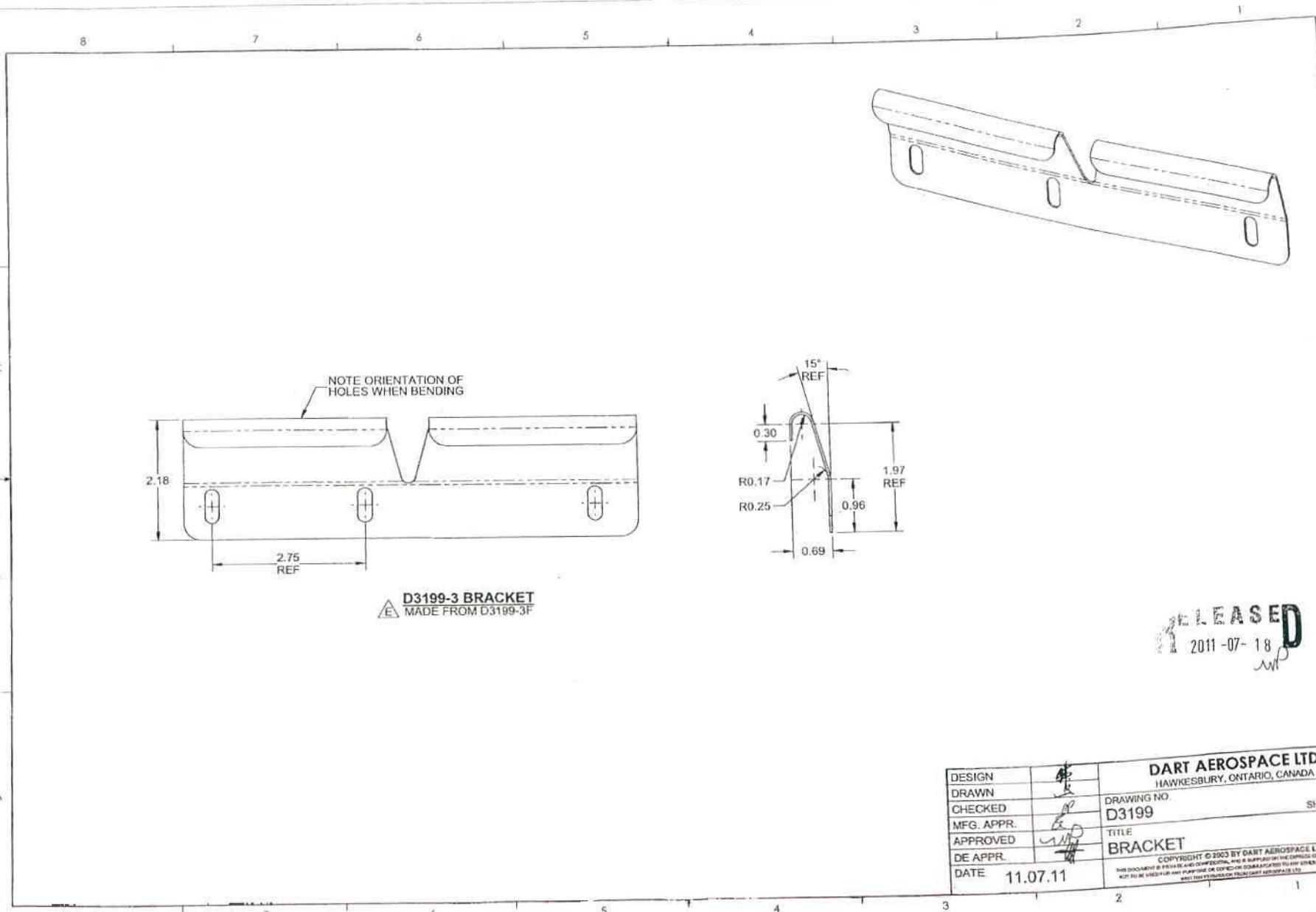
304/316 .040 Sheet

Location	Loc Qty	Loc Code
MAT020	137.0795	
116623	0.2	
117550	8.363	
117933	43.3442	117933
118400	25.6723	
118964	59.5	

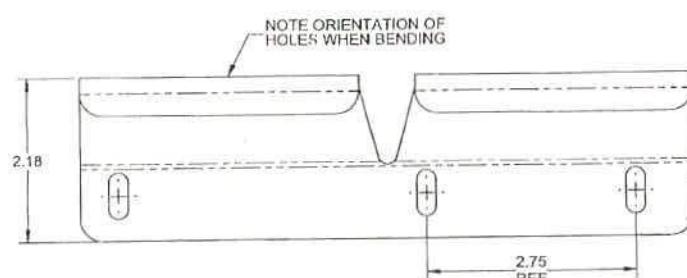
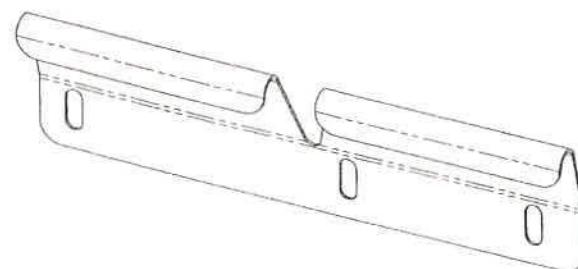


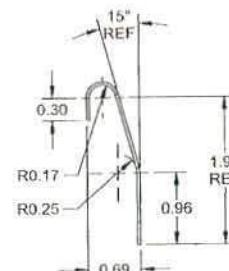
75216



75206



D3199-4 BRACKET  
MADE FROM D3199-3F

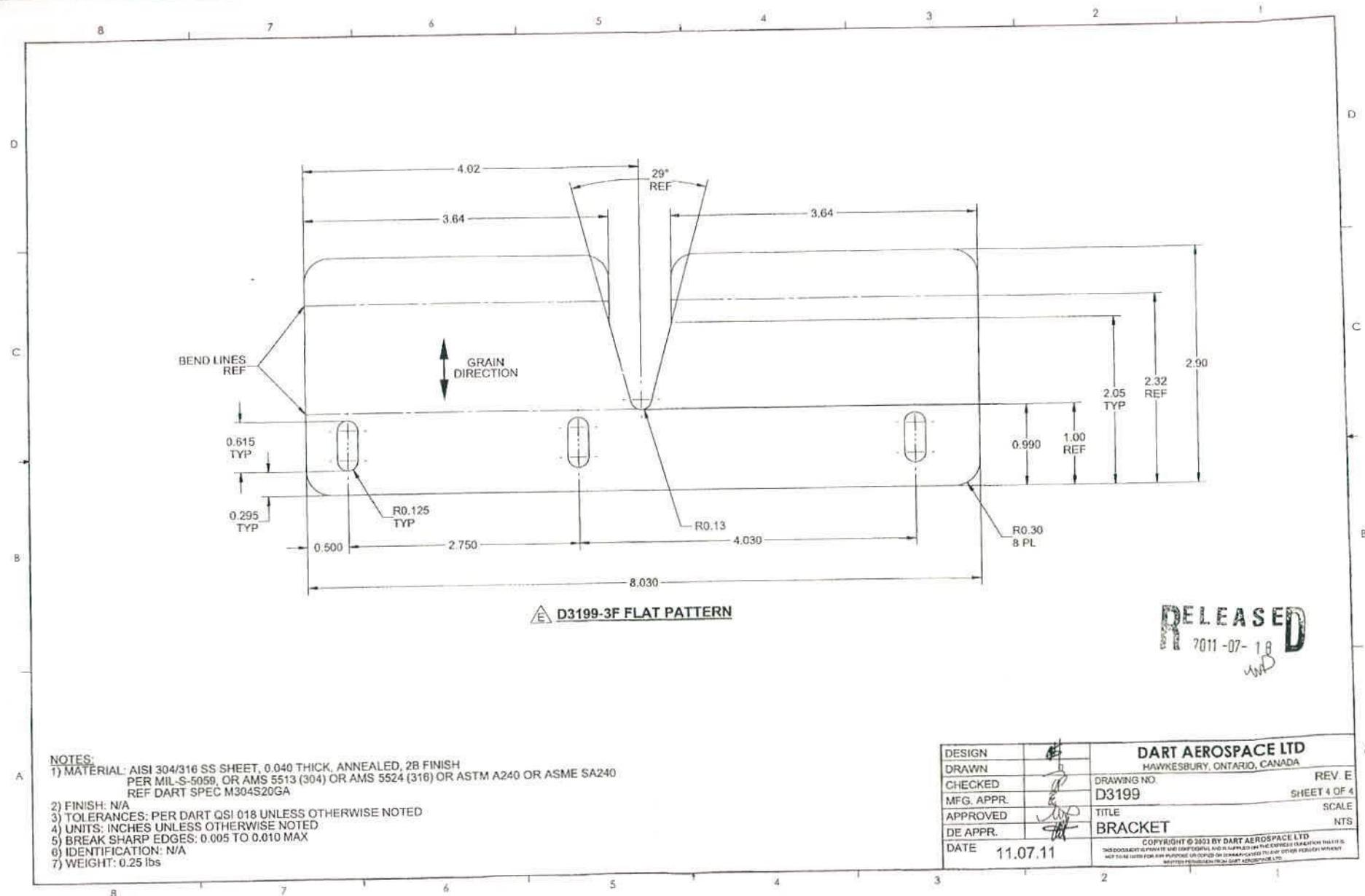


RELEASED  
2011-07-18  
M

DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>[Signature]</i>	REV. E
MFG. APPR.	<i>[Signature]</i>	DRAWING NO. D3199
APPROVED	<i>[Signature]</i>	SHEET 3 OF 4
DE APPR.	<i>[Signature]</i>	TITLE BRACKET
DATE	11.07.11	SCALE NTS

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752-06



DART AEROSPACE LTD

Work Order: 75206

Description: BLACK

Part Number: D3194-3

inspection Dwg: 13199-3 Rev:

as 10<sup>4</sup> s

#### FIRST ARTICLE INSPECTION CHECKLIST

First Article       Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.64 $\pm$ .30	.30	3.640	X		V	
4.02 $\pm$ .22	.22	4.022	?			
2.90 $\pm$ .06	.06	2.904	C			
1.80 $\pm$ .06	.06	1.803	?			
.614 $\pm$ .06	.06	.618	?			
.295 $\pm$ .06	.06	.294	?			
.500 $\pm$ .06	.06	.501	?			
2.756 $\pm$ .06	.06	2.754	?			
4.030 $\pm$ .06	.06	4.033	?			
8.030 $\pm$ .06	.06	8.039	?			
.040 $\pm$ .06	.06	.044	?			

Measured by: ✓

Date: 11-10-19

Audited by:

Date: 11/10/05

#### Prototype Approval:

Digitized

Rev Date Change  
A New Issue

Revised by      Approved